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EUROPEAN PATENT APPLICATION

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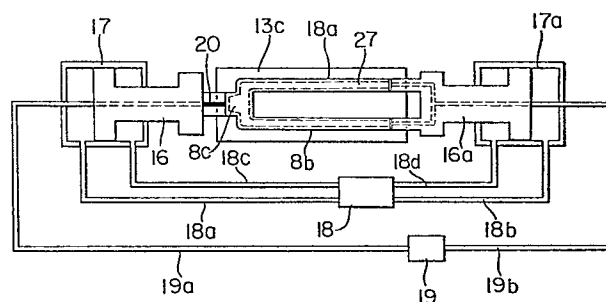
⑧④ Designated Contracting States: **DE FR GB IT**

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⑤④ **Method for the manufacture of front fork of single unit type for bicycles from center butted ferrous tubular material.**

⑤⑦ A front fork blank of the single unit type is manufactured from a center butted tube, the wall thickness of its middle portion exceeding that of both end portions of the tube, as a starting material. The center butted tube (2) is produced by a known machine including a mandrel (15) and a die (14). The center butted tube is bent at two positions with the right angle to form a tubular fork (5). The tubular fork (5) is set in a sectional die which has a concave recess corresponding to a protuberant socket, and subjected to the known oil hydraulic bulge-forming process in order to bulge-form the socket at the middle of the top of the tubular fork. The socket is opened to receive a stem.





European Patent
Office

EUROPEAN SEARCH REPORT

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EP 83 10 1399

DOCUMENTS CONSIDERED TO BE RELEVANT															
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. ³)												
D,A	US-A-4 305 269 (KIMURA) * Claim 1; figure 9 *	1	B 21 D 53/86												
D,A	--- US-A-4 051 704 (KIMURA) * Claim 1; figure 3 *														
A	--- FR-A- 477 835 (FURAN)														
A	--- DE-A-3 021 481 (MANNESMANN)														
A	--- DE-C-1 037 394 (HUET)														
A	--- DE-C- 129 875 (STIEFEL) -----														
The present search report has been drawn up for all claims															
Place of search BERLIN		Date of completion of the search 14-12-1983	Examiner SCHLAITZ J												
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